

Work Order ID 85594

85594

Page 1

June-12-12 8:38:12 AM

Item ID: DSI 9577-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cushion Installation

Start Date: 12/06/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9577	A								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP DSI 9577-011		CHG001						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

SP

6/26/12

15x

SP
12-7-5

6/26/12

(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85594

June-12-12 8:38:12 AM

85594

Page 2

Item ID: DSI 9577-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cushion Installation

Stop ***NS2***

Start Date: 12/06/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI 9577-011

Location:

PPP rev:

DRAFT

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

6/12/12 15

MLJ 12/07/12

MF 12-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 8:38:16 AM

Page 1

Work Order ID: 85594

85594

Parent Item: DSI 9577-011

DSI 9577-011

Parent Item Name: Cushion Installation

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4404-1		Manufactured	No			110	Each	1.0000		15			
---------	--	--------------	----	--	--	-----	------	--------	--	----	--	--	--

D4404-1

Cushion

Location

ST242A

Loc Qty

1

Loc Code

75181

1

D4404-5		Manufactured	No			110	Each	5.0000		15			
---------	--	--------------	----	--	--	-----	------	--------	--	----	--	--	--

D4404-5

Cushion, Fwd

Location

ST242A

Loc Qty

5

Loc Code

76899

1

85349

4

D4404-7		Manufactured	No			110	Each	5.0000		15			
---------	--	--------------	----	--	--	-----	------	--------	--	----	--	--	--

D4404-7

Cushion, Upper Side

Location

ST242A

Loc Qty

5

Loc Code

79119

2

80754

3

D4404-9		Manufactured	No			110	Each	5.0000		15			
---------	--	--------------	----	--	--	-----	------	--------	--	----	--	--	--

D4404-9

Cushion, Lower Side

Location

ST

Loc Qty

-6

Loc Code

79120

2

ST242B

11

80755

3



**

4x B87036
B85595 8x.
2x B86486 8.



**

1x
B85596 15 6
SP.



**

2x B85597 8x.
2x B86487.



**

3x B85598 6x.
5x B86488.
1x
3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-794 REV. C OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-794 REV. 2 OR EARLIER

REF. TCCA STC: SH05-4
REF. EASA STC: 10031514
REF. BRAZIL STC: 2002S09-07/-08
REF. AUSTRALIAN STC: ASR063SY

PURPOSE:

TO PROVIDE INSTRUCTIONS THAT ALLOW INSTALLATION OF D4404-1/-5/-7/-9 NEOPRENE CUSHIONS
TO PREVENT THE D4055-041 AUX. FUEL TANK FROM CHAFING IN SERVICE.

CHANGE:

D350-794-011, D130-794-021, AND D350-794-041 KITS AT CHG 005 OR LATER ARE SUPPLIED TO
CUSTOMERS/OPERATORS WITH D4404-1/-5/-7/-9 NEOPRENE CUSHIONS INSTALLED ON D4055-041
AUXILIARY FUEL TANK. CUSTOMERS/OPERATORS WITH D130-794-021 AND D350-794-041 KITS AT
CHG 004 AND EARLIER CAN PROCURE DSI-9577-011 KIT FROM DART TO UPGRADE THEIR KITS.

PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9577-011	CUSHION INSTALLATION
1	D4404-1	CUSHION
1	D4404-5	CUSHION, FWD
1	D4404-7	CUSHION, UPPER SIDE
1	D4404-9	CUSHION, LOWER SIDE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85594 MJS
12/26/12

INSTALLATION:

INSTALL THE D4404-1/-5/-7/-9 CUSHIONS IN ACCORDANCE WITH FIGURE 1 OF THIS SERVICE
INSTRUCTIONS AFTER COMPLETING STEP 5.2.8 OF THE ANNUAL/100 HOUR INSPECTION OF ICA-
D350-794 BY APPLYING A THIN, UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP
ADHESIVE OR EQUIVALENT). TRIM TO FIT IF REQUIRED.

WEIGHT AND BALANCE:

THE FOLLOWING TABLE LISTS THE NEW WEIGHT AND BALANCE OF THE -011/-021 KITS AT CHG 005
OR LATER OR AFTER DSI-9577-011 KIT HAS BEEN INSTALLED.

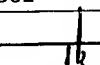


INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-794-011 AUXILIARY FUEL TANK (CHG 005) (AS350 MODELS)	32.7 lb 14.8 kg	-22.0 in -0.56 m	-719.4 in-lb -8.29 m-k-g	126.0 in 3.20 m	4120.2 in-lb 47.4 m-k-g
D130-794-021 AUXILIARY FUEL TANK (CHG 005) (EC130 MODELS)	32.7 lb 14.8 kg	-23.6 in -0.60 m	-771.7 in-lb -8.88 m-k-g	126.0 in 3.20 m	4120.2 in-lb 47.4 m-k-g

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

A	NEW ISSUE	MB	11.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION INSTALLATION	NTS
DATE	11.10.04	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

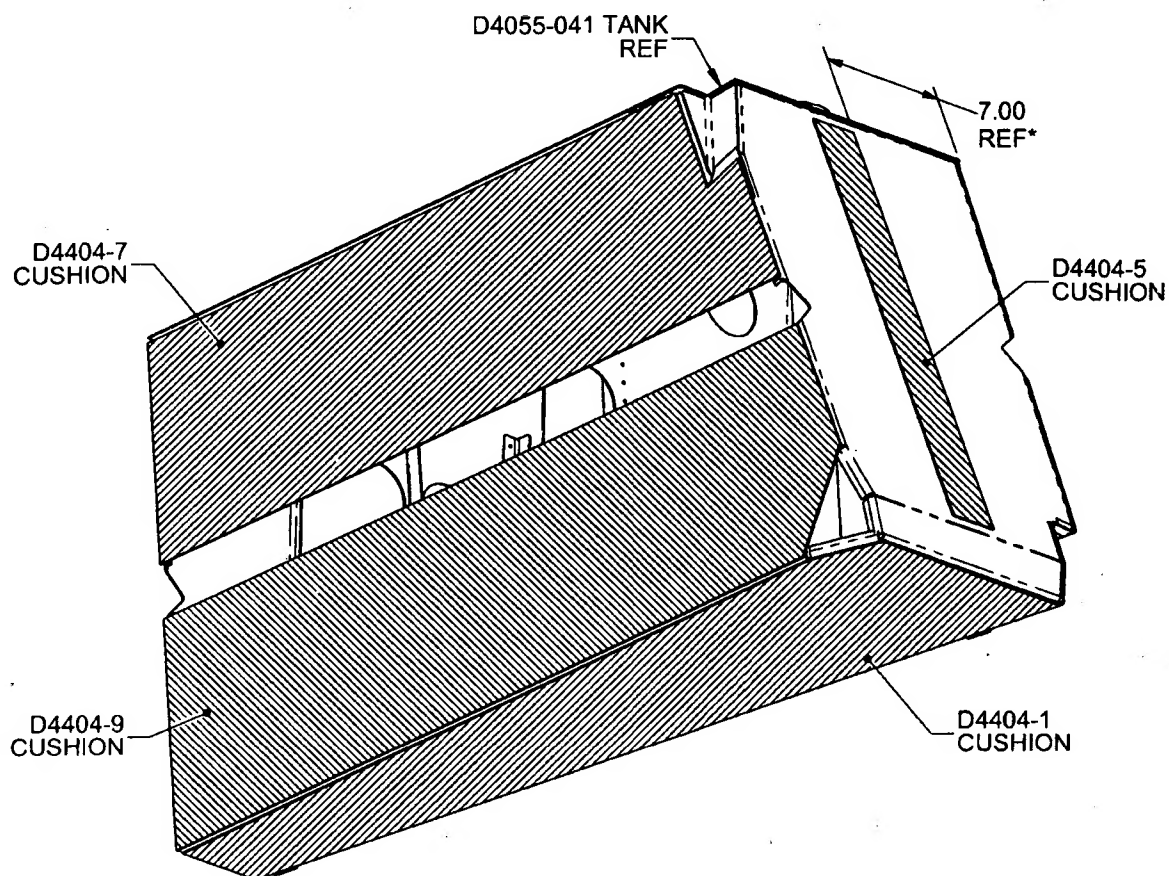
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries








*: ALIGN D4404-5 WITH FORWARD RESTRAINT BEAM (EXISTING ON AS350, D4005-3 ON EC130)

FIGURE 1 - CUSHION INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION INSTALLATION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-794 REV. C OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-794 REV. 2 OR EARLIER

REF. TCCA STC: SH05-4
REF. EASA STC: 10031514
REF. BRAZIL STC: 2002S09-07-08
REF. AUSTRALIAN STC: ASR063SY

PURPOSE:

TO PROVIDE INSTRUCTIONS THAT ALLOW INSTALLATION OF D4404-1/-5/-7/-9 NEOPRENE CUSHIONS
TO PREVENT THE D4055-041 AUX. FUEL TANK FROM CHAFING IN SERVICE.

CHANGE:

D350-794-011, D130-794-021, AND D350-794-041 KITS AT CHG 005 OR LATER ARE SUPPLIED TO
CUSTOMERS/OPERATORS WITH D4404-1/-5/-7/-9 NEOPRENE CUSHIONS INSTALLED ON D4055-041
AUXILIARY FUEL TANK. CUSTOMERS/OPERATORS WITH D130-794-021 AND D350-794-041 KITS AT
CHG 004 AND EARLIER CAN PROCURE DSI-9577-011 KIT FROM DART TO UPGRADE THEIR KITS.

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
-011		
X	DSI-9577-011	CUSHION INSTALLATION
1	D4404-1	CUSHION
1	D4404-5	CUSHION, FWD
1	D4404-7	CUSHION, UPPER SIDE
1	D4404-9	CUSHION, LOWER SIDE

INSTALLATION:

INSTALL THE D4404-1/-5/-7/-9 CUSHIONS IN ACCORDANCE WITH FIGURE 1 OF THIS SERVICE
INSTRUCTIONS AFTER COMPLETING STEP 5.2.8 OF THE ANNUAL/100 HOUR INSPECTION OF ICA-
D350-794 BY APPLYING A THIN, UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP
ADHESIVE OR EQUIVALENT). TRIM TO FIT IF REQUIRED.

WEIGHT AND BALANCE:

THE FOLLOWING TABLE LISTS THE NEW WEIGHT AND BALANCE OF THE -011/-021 KITS AT CHG 005
OR LATER OR AFTER DSI-9577-011 KIT HAS BEEN INSTALLED.

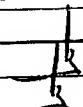



INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
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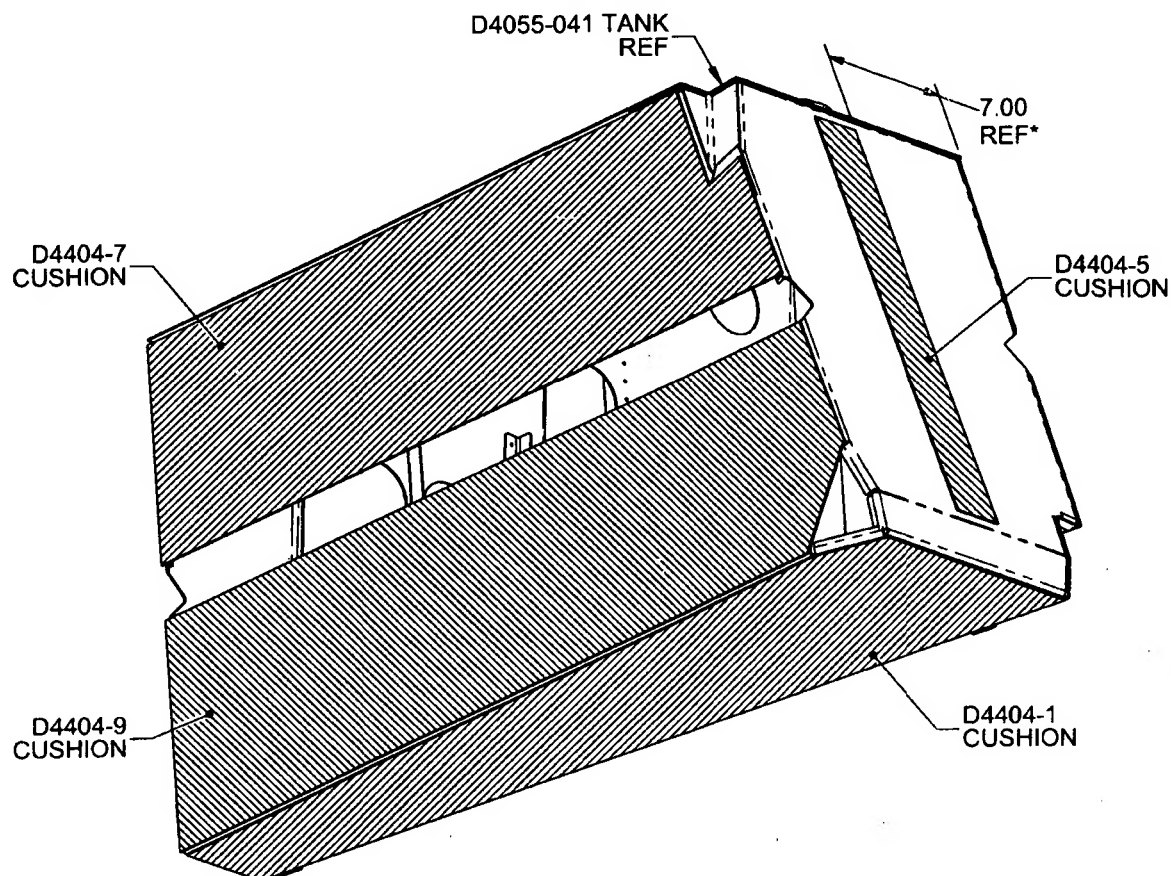
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

A	NEW ISSUE	MB	11.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION INSTALLATION	NTS
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*: ALIGN D4404-5 WITH FORWARD RESTRAINT BEAM (EXISTING ON AS350, D4005-3 ON EC130)

FIGURE 1 - CUSHION INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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Work Order ID 85594

June-12-12 8:38:12 AM

85594

Page 1

Item ID: DSI 9577-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cushion Installation

Start Date: 12/06/2012 Start Qty: 15.00 ***15***Required Date: 26/06/2012 Req'd Qty: 15.00 ***15***

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan: ML5 Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9577	A								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP DSI 9577-011	CHG001							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

12/7/5